

Date: Wednesday, 26/11/2008 12:45:42 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: ASPIRATOR BODY		
Job Number	: 43741			Part Number	: D2094		
Estimate Number	: 11975			Drawing Number	: D2094 REV A		
P.O. Number	:			Project Number	: N/A		
This Issue	: 26/11/2008	S.O. No.	:	Drawing Revision	: A		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: SMALL /MED FAB	Due Date	: 10/12/2008		
Previous Run	: 30153			Qty:	20		
Written By	:			Um:	Each		
Checked & Approved By	: <u>JUL 08.11.26</u>						
Comment	: Est. B 99.01.20 Re-format DM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :								
1.0	D2061	Aspirator								
Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)										
Aspirator										
Pick:										
<table border="1"> <thead> <tr> <th>Qty</th> <th>Part number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>D2061</td> <td>Aspirator Body</td> <td>43582</td> </tr> </tbody> </table>			Qty	Part number	Description	Batch	1	D2061	Aspirator Body	43582
Qty	Part number	Description	Batch							
1	D2061	Aspirator Body	43582							
2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1								
Comment: SMALL & MEDIUM FAB RESOURCE 1										

1	Drill 4 flange holes as per Dwg D2092/93/94using Drill Jig DT 8262	FF 09/02/05
2	Cut edges as per Dwg D2095 using Jig DT 8263	
3	Drill 5/16 hole for jet as per Dwg D2092/93/94using Drill Jig DT 8296	FF 09/02/06
4	Deburr	m-f 09/02/05
5	Clean and polish with water and thinner	FF 09/02/06

3.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP

S 09/02/04 (420)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2094 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 09/02/12

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: 43741		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/2/10	# 2.3	During inspection found 3 parts with 0.3125" (5/16") hole too large. R.C. Drill withdraws when drilling at back of case.	09/04/12	- Acceptable deviation at this time only. Will be corrected upon welding. He ASS'Y. - Ensure to take more care & more attention when drilling	FF 09/02/11	S 09/02/11	/	/

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

4.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: STL71

AS 09/02/12 (x2)

5.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-02-12

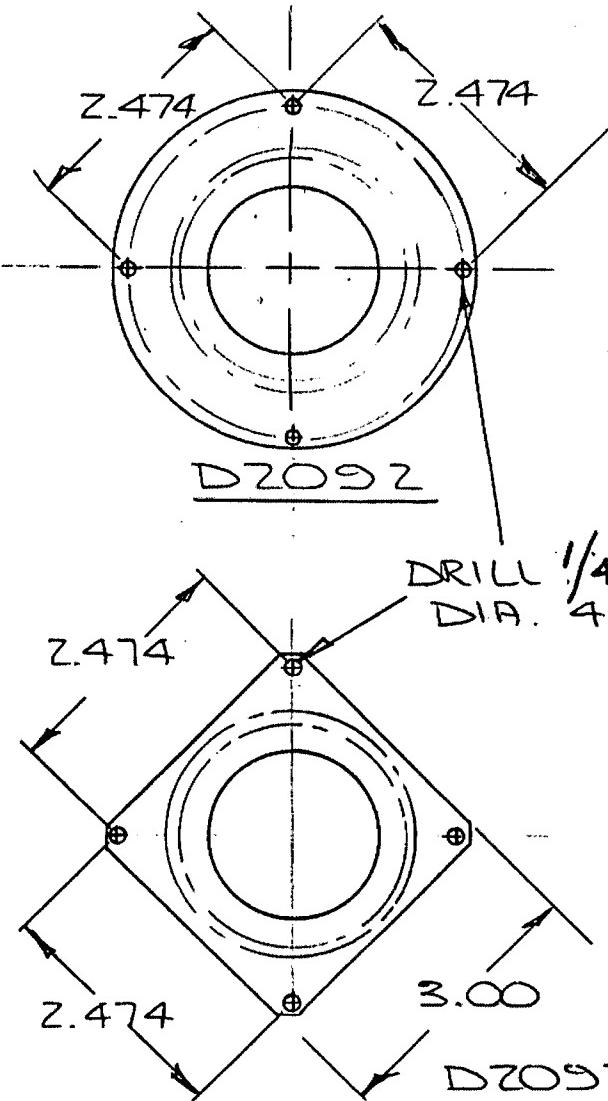
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

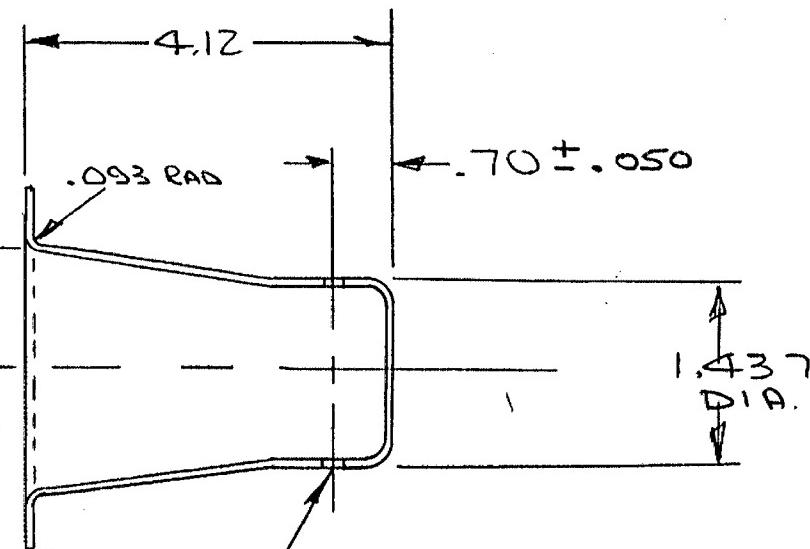
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 4324



DRILL $\frac{5}{16}$ (.312) DIA THRU
AS SHOWN ON D2092
AND D2093. ROTATE 45°
ON D2094.

MATERIAL: 1100-O, .063-
SPIN FROM
SHEET STOCK

A	REVISION	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.		RIVET CODE SHALL BE PER NAS 523	PART NO.	ITEM	DESCRIPTION	MATERIAL	SPEC./VENDOR	
Blair TJW/15	DRAWN			BASIC CODE	DIA. DASH. NO. N=HEAD NEAR SIDE F=HEAD FAR SIDE		CONTRACT NO.	DART AERO ACCESSORIES INC. VANCOUVER CANADA		
	APPROVED			D=DIMPLE DGT=NO. OF SHEETS C=COUNTERSINK	LENGTH DASH NO. W=SPOTWELD		DRAWN			
<i>1/14/05 was A 1/15/05 was B 1/15/05 was C 1/15/05 was D 1/15/05 was E</i>	DESCRIPTION OF CHANGE	REQUIREMENTS — UNLESS OTHERWISE SPECIFIED		BASIC CODES		DESIGN	<i>DA</i>	<i>1992</i>	COPY IS <i>5</i>	
		GENERAL	UNITS	BJ=M52047AD BB=M52048AD		STRESS	TITLE			
1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS $\frac{1}{16}$ " 3. REMOVE SHARP EDGES .015 MAX 4. THREADS PER IN. = 2742 5. HOLES PER INCH 10287 1. TOLERANCES — JIG ± .030 JUCK ± .010 2 ANGLES ± .5° 3 PARALLELISM .0025 4. ECCENTRICITY .005 MAR. 5. DIMINUTRY ABOUT ALL M/C CENTRE LINES .003				CHECKED						
REPORT ALL DISCREPANCIES — DO NOT SCALE										
		CODE	DWG NO		SCALE	1:2	SHT	OF	REV.	
		<i>DZ097/93/94</i>							<i>A</i>	

REPORT ALL DISCREPANCIES - DO NOT SCALE